

Date: Thursday, 19/10/2006 10:57:10 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 29076
 Estimate Number : 11039
 P.O. Number : N/A
 This Issue : 19/10/2006 S.O. No. : N/A
 Prsh Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : 28181
 Written By : 
 Checked & Approved By : 
 Comment : Est. A00.11.06 New Issue EC
 Est. B06.05.30 Blanks on wtjetEC

Drawing Name : STA 155 BRACKET - UNDER REVIEW
 Part Number : D28041 *Prep. C. J.*
 Drawing Number : D2804 REV.B
 Project Number : N/A
 Drawing Revision : UNDER REVIEW
 Material :
 Due Date : 20/10/2006 Qty: 2 Um: Each

PRELIMINARY ISSUE

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X12000 	6061-T6 Bar .50" x 12.0"
	Comment: Qty.: 0.7875 f(s)/Unit Total : 1.5750 f(s) 6061-T6 Bar .50" x 12.0" Material: 6061-T6 bar 12.00" x 0.50"	Batch: M100046 <i>M 06/10/19</i>
2.0	WATER JET 	FLOW WATER JET 
	Comment: FLOW WATER JET 1-Cut as per Template DT8534 Dwg Rev: <i>B</i> Prog Rev: <i>B</i>	<i>M 06/10/19</i> (2)
	2-Deburr if necessary	
3.0	HAAS1 	HAAS CNC VERTICAL MACHINING #1 
	Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA103	<i>M 06/10/19</i> 2
4.0	QC2 	INSPECT PARTS AS THEY COME OFF MACHINE 
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>M 06/10/19</i> 2
5.0	QC8 	SECOND CHECK 
	Comment: SECOND CHECK	<i>Sp 06/10/20</i> x2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/10/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STA 155 BRACKET - UNDER REVIEW

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Part Number: D28041

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble & Deburr	<i>ml 06/10/20 2</i>
7.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	<i>50 06/10/20 x2</i>
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	<i>a. m 06/10/20 2</i>
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	<i>Acu/10/20 2</i>
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	<i>50 06/10/20 2</i>

Job Completion



u 06/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD		Amendment Design Review (ADR) Yes/No:	ECN #:
Date:	06.10.19	ADR Date:	865
Job No:	06075	Created By:	
Product No:	D412-630	Approved By:	
Product Name:		(Proj. Manager)	Approved By: (Management if reqd)

Documents Affected:

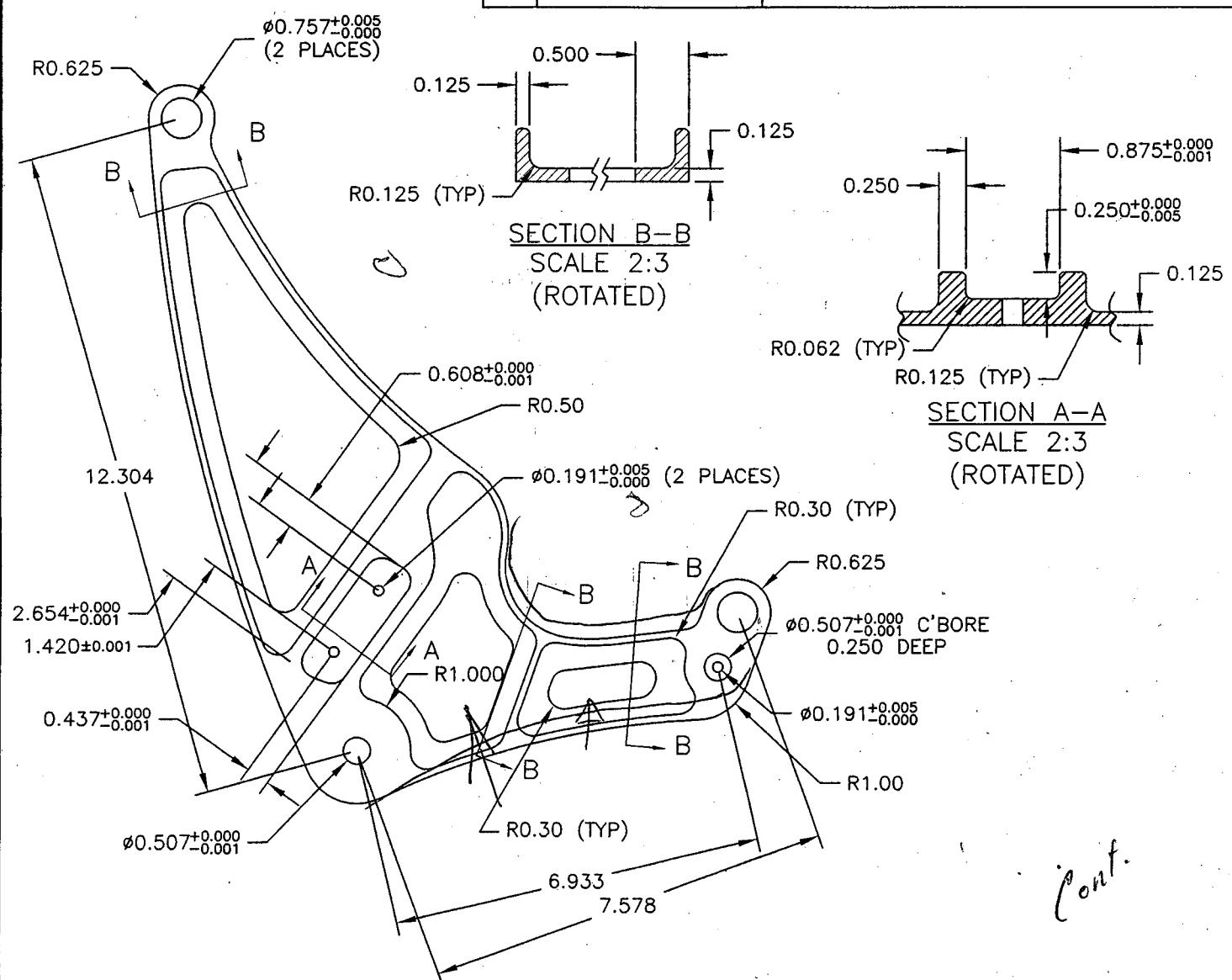
RELEASE D2804 Rev C Preliminary Issue

#	Engineering Actions	Yes	No	Responsible	To happen by:	Complete
1	Required Documents/Drawings Under Review?	✓				
2	Update Blue/Pink Folder/Electronic File		✓			
3	Update DSI Folder/Electronic File		✓			
4	Update D-Part Master Binder		✓			
5	Update Grey Project Binder		✓			
6	Update DEO/DSI Binder		✓			
7	Update Master Document List (MDL)		✓			
8	Update Document Record (DR)		✓			
9	Update Change Record Form		✓			
10	Move Electronic File		✓			
11	Notify TC of Change		✓			
12	Notify FAA of Change		✓			
13	Update QSI 021 (TC/FAA STC)		✓			
14	Update QSI 036 (K-Kits)		✓			
15	Update Accpac Database		✓			
16	Update Access Database		✓			
17	Verification ARC		✓			
18	Update STC Approval List		✓			
19	Update Product Development Summary		✓			
20	Create/Update COSS (Estimate/BOM)	✓		JLM/EC		
21	Create/Update PPP's		✓			
22	Update Paperwork Kits in Production		✓			
23	Update Paperwork Kits in Stock		✓			
24	Red Tag Stock with old CHG #		✓			
25	Rework/Scrap Current Production		✓			
26	Rework/Scrap Kits in Stock?		✓			
27	Update Qpulse/Laminated Dwgs		✓			
28	Create/Update Controlled PDF Files		✓			
29	Create/Update FAI sheets	✓		JLM/EC		
30	Create/Update CNC Programs	✓		JLM/EC		
31	Create/Update Tooling	✓		JLM/EC		
32	MPP required?		✓			
33	Notify Previous Customers	✓		CP		
34	Notify Eurocopter France	✓				
35						
36						

Description / Action:

- WE NEED QTY(1) D2804-091, finished and assembled ASAP
- LL? we need QTY(1) D2803-091 (MADE TO D2803 Rev B) and QTY(1) D2804-041 (MADE TO D2804 Rev C Prelim. Issue) READY TO SHIP TO CUSTOMER FRIDAY 20th

ECN Complete: _____ Date: _____

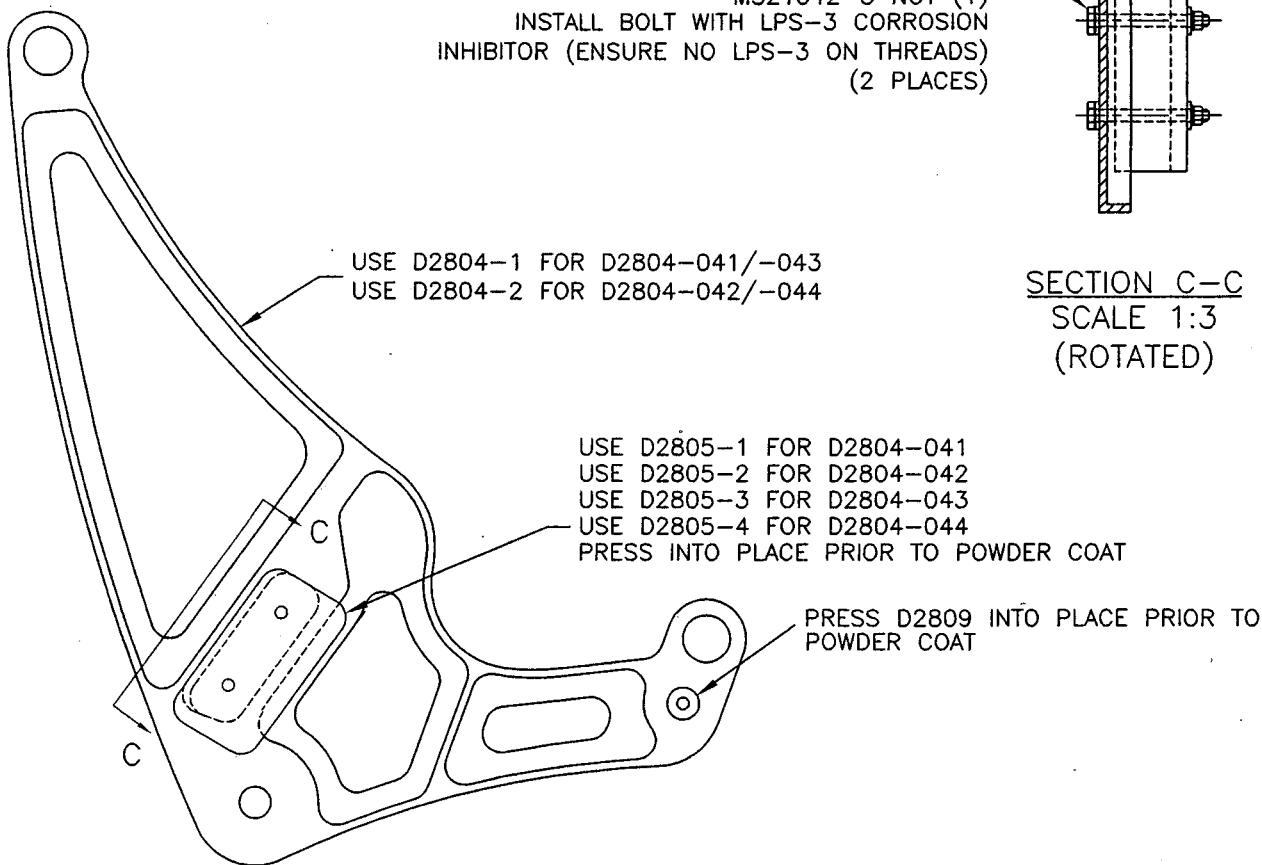


D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D2804
DATE	06.10.16			REV. C SHEET 2 OF 2 SCALE 1:3



D2804-041/-043 BRACKET ASS'Y (SHOWN)
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3

DART AEROSPACE LTD	Work Order:	29076
Description: STA 155 BRACKET	Part Number:	D2804-1
Inspection Dwg: D2804 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<u>Prin</u>	Audited by:	<u>MS</u>	Prototype Approval:	<u>CP</u>
Date:	06/10/19	Date:	06/10/19	Date:	06.10.19

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	